

Work Order ID: 66345

Thursday, February 10, 2011 1:37:32 PM

Page 1

Item ID: D206-667-203

Accept

Setup Start

Revision ID:

Stop

Item Name: Crosstube Aft

Start Date: 2/11/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 2/25/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D206-667-243

Rev C

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels as per PPP D206-667-203 CHG003

Sub 6/21

11-4-21

110

0.00



BENDING MACHINE - CROSSTUBES

CNC Bend 2

Memo

0.00

CNC Alpha 160 Bender

Bend tube as per Dwg D206-667-243 using CNC bender program 206L-AF

DP

11-3-24

120

QC15- Crosstube Dimensional Check

0.00



QC

Memo

0.00

Quality Control

11-6/25

@

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 66345

Thursday, February 10, 2011 1:37:33 PM



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Customer:

Reference:

Run Start



Stop



Approvals: Process Plan: Date: Tooling: Date:

QC: Date: SPC (Y/N): Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00



Crosstubes

Crosstubes

Memo

0.00

Crosstubes

1-Drill pilot holes in tube using drill Jig DT8583 & DT8584 as per Dwg D206-667-243 and drill table DT8577. Locate hole #6 for towers as per QSI 10. Drill all (3) top holes.

2-Drill and Ream all holes in tube to finish size using drill Jig DT8583 & DT8584 as per Dwg D206-667-243 Check dimensions between holes on all four sides.

3-Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins.

4-Drill pilot holes using drill Jig DT8583 & DT8584 as per Dwg D206-667-243. Drill only the top (2) holes.

5-Drill & ream the top (2) holes to finish size using drill Jig DT8583 & DT8584 as per Dwg D206-667-243

6-Drill Fwd rivet holes using drill Jig DT8789FWD as per Dwg D206-667-143. Note: Fwd side has 3x top holes.

7-Drill Aft rivet holes using drill Jig DT8789 as per Dwg D206-667-243.

8-C'sink holes as per Dwg D206-667-243.

9-Scribe part # and batch # using vibrating stylus as per Dwg D206-667-243 Inside of Cuff (Do not engrave on outside of tube)

10-Deburr & Inspect for surface damage. Repair damage within limits as per

BB
BE 11/03/30

SAH
11-04-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Cust Item ID:

Required Date: 2/25/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
StampDwg
D206-667-243

140

Crosstubes Chemical Conversion

0.00



HandFXtube

Memo

0.00

Hand Finishing Crosstubes

SAD
11-04-01

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

S 11/04/01

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

S 11/04/01



W/O:		WORK ORDER CHANGES					
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Customer:




Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170  Outsource2	Outsource process - NDT per QSI038 4.1	0.00							
Outsource process - NDT	Memo Liquid Penetrant Inspection as per QSI 038Or Issue P/O: <u>13801</u> LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order	0.00							CL 11/04/05 ①
180  Packaging	Packaging	0.00							
Packaging	Memo Ensure copy of NDT results attached to work order.	0.00							P 11/04/05 ①
190  QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo Ensure results are as per Dwg D206-667-243	0.00							M 11 04 05 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Cust Item ID:

Required Date: 2/25/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200

0.00



SprayPaint

SprayPaint

Memo

0.00

Spray Painting

1-Prime inside and outside crosstube as per QSI 005 4.2
2-Paint outside crosstube with White Imron as per QSI 005 4.2

PRIME:

Start Time: 9:00

Finish Time: 10:00

PAINT:

Start Time: 3:00

Finish Time: 4:00

11 - 04 - 18 (1)

210

0.00



QC14- Inspect Spray Paint

QC

Memo

0.00

Quality Control

Wrap in plastic bag to protect from scratches

11 - 04 - 19 (x1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Start Date: 2/11/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 2/25/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220		0.00							
	Crosstubes								
Crosstubes	Memo	0.00							
Crosstubes	1-Install nut plates as per Dwg D206-667-243.								
230		0.00							
	Skidtubes								
Crosstubes	Memo	0.00							
Crosstubes	1-Install support using 0.03" to 0.06" thick layer of magnobond 6398 per QSI 015. Let cure for 12h after installation and prior to packaging. Note: (3) top holes should be facing up. A/R Magnobond 6398 : <u>116677</u>								
	2-Install supports and clamps as per Dwg D206-667-243. Torque clamps to 80-100 in lb								

RT 11-04-20

RT 11-04-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 66345

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Item ID: D206-667-203

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Aft

Start Date: 2/11/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 2/25/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				<u>MA</u>	<u>11</u>	<u>04</u>	<u>21</u> (1)
250 Packaging Packaging	Pick Kit Memo	0.00 0.00				<u>11/4/21</u>			
260 QC Quality Control	QC4- 100% Inspect kits for completeness Memo	0.00 0.00				<u>8 u loc/21</u>			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 66345

Thursday, February 10, 2011 1:37:33 PM

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Item ID: D206-667-203

Accept

Setup Start

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Stop

Item Name: Crosstube Aft

Start Date: 2/11/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 2/25/2011 Req'd Qty: 1.00

Customer:



Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270		0.00							
	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D206-667-203								
	Location: <u>53</u>								
	PPP Rev: <u>D</u>								
280		0.00							
	QC21- Final Inspection - Work Order Release								
QC	Memo	0.00							
Quality Control									

11/4/21

11/4/21

MF
11-04-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, February 10, 2011 1:37:25 PM

Page 1

Work Order ID: 66345

Parent Item: D206-667-203

Parent Item Name: Crosstube Aft



Start Date: 2/11/2011

Required Date: 2/25/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:F 05.09.01 Add holes for compatibility with Bell Skidtubes KJ/JLM
IPP Rev:G 08-06-03 update as per DSI9415 (ECN1198) DD verified by:ec
IPP Rev:H 08-07-18 remove thread masking in step 12 DD verified by:EC
IPP Rev:I 08-12-15 add magnobond DD verified by:EC
IPP Rev J 09.01.06 ECN 08-562 EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN5-10A Bolt		Purchased	No			250	Each	168.0000	10	10			

Location	Loc Qty	Loc Code
ST337	168	
115589	50	
115700	68	
116704	50	

AN5-32A Bolt		Purchased	No			250	Each	149.0000	4	4			
---------------------	--	-----------	----	--	--	-----	------	----------	---	---	--	--	--

Location	Loc Qty	Loc Code
ST340	149	
115016	38	
115108	50	
115589	60	
115698	1	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, February 10, 2011 1:37:26 PM

Work Order ID: 66345

Parent Item: D206-667-203

Parent Item Name: Crosstube Aft

Start Date: 2/11/2011

Required Date: 2/25/2011

Start Qty: 1.00

Required Qty: 1.00

AN5-34A

Purchased

No

250

Each

68.0000

4

4



Bolt

Location

Loc Qty

Loc Code

ST340

68

113149

2

115835

20

116003

20

116191

6

116704

20

AN960JD516

NAS1149D0563J

Purchased

No

250

Each

34.0000

18

18



Washer

Location

Loc Qty

Loc Code

ST

34

103694

18

107534

12

109287

4

D206-667-203TRN

Manufactured

No

220

Each

2.0000

1

1



Crosstube Turning Detail

Location

Loc Qty

Loc Code

LG

2

65133

1

65134

1

B670001

ODP 11-3-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Picklist Print

Thursday, February 10, 2011 1:37:27 PM

Work Order ID: 66345

Parent Item: D206-667-203

Parent Item Name: Crosstube Aft

Start Date: 2/11/2011

Required Date: 2/25/2011

Start Qty: 1.00

Required Qty: 1.00

D2873-043

Manufactured No

220

Each

24.0000

2

2



Nut Plate Assembly

66898



25 11-04-20

Location

Loc Qty

Loc Code

LG

22

63497

2

65375

20

ST

2

60981

2

D2873-045

Manufactured No

220

Each

24.0000

2

2



Nut Plate Assembly

67741



25 11-04-20

Location

Loc Qty

Loc Code

LG

24

60982

4

63498

1

65132

19

D2892-1

Manufactured No

230

Each

30.0000

2

2



Support

B 65717



25 11-04-20

Location

Loc Qty

Loc Code

LG

30

41986

2

42785

18

62592

10

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 66345



Parent Item: D206-667-203



Parent Item Name: Crosstube Aft

Start Date: 2/11/2011

Required Date: 2/25/2011

Start Qty: 1.00

Required Qty: 1.00

D3595-063-450

Manufactured

No

230

Each

68.3390

4

4



B67353



BT 11-04-20

RUBBER CUSHION

Location

Loc Qty

Loc Code

LG

51.33897368

53775

5.97897368

58161

3.56

59580

0.12

61465

4.68

63960

10

65656

27

ST415

17

64171

16

64300

1

MS20601-AD4W10

Purchased

No

230

Each

150.0000

14

14



BT 11-04-20

RIVET

Location

Loc Qty

Loc Code

LG051

150

114245

2

115405

2

115881

16

116186

30

116767

100

X 14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 66345

Parent Item: D206-667-203

Parent Item Name: Crosstube Aft

Start Date: 2/11/2011

Required Date: 2/25/2011

Start Qty: 1.00

Required Qty: 1.00

MS21042L5

Purchased

No

250

Each

1,108.000

4

4



Nut



11/4/11

Location

Loc Qty

Loc Code

ST139

26

114813

26

ST300

1082

115594

386

116105

496

116548

200

4

4

MS21920-22

Purchased

No

230

Each

56.0000

4

4



Clamp(per MIL-DTL-8783C)



117279

11-04-20

Location

Loc Qty

Loc Code

LG

56

114077

6

116207

50

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

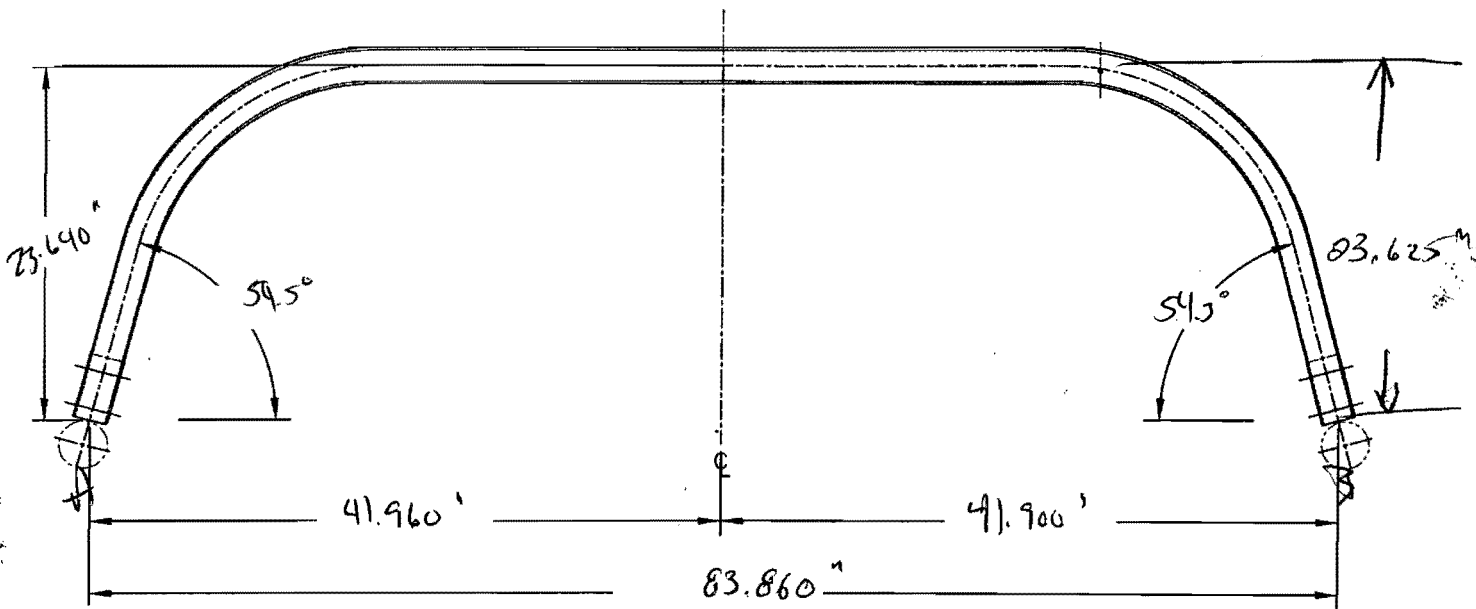
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 66345
Description: Crosstube High Aft (206L)		Part Number: D206-667-203
Inspection Dwg: D206-667-243 Rev: C		Page 1 of 1

Required Dimension	Min	Max
Height	23.39	23.65
1/2 Span	41.79	42.05
Angle	54	56
Total Span	83.58	84.1



Comments

QC15 Inspection	J 11/03/25
Date	

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	09.11.17	Dwg Rev updated	KJ	
C	09.12.14	Dimensions update per Dwg Rev C	KJ	

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Item	Qty -243	Part Number	Description
1	X	D206-667-243	CROSSTUBE ASSEMBLY (206L HIGH AFT)
2	1	D6004-115	CROSSTUBE
3	2	D2873-043	NUT PLATE
4	2	D2873-045	NUT PLATE
5	2	D2892-1	SUPPORT
6	4	D3595-063-450	RUBBER CUSHION
7	4	MS21920-22	CLAMP
8	14	MS20601AD4W10	RIVET (OR NAS9302B-4-10)
9	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299- 947-100, TYPE II, CLASS 2 ADHESIVE)

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6004-115
FINISHED LENGTH = 104.91±0.020
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D206-667-243" AND BATCH NUMBER ON
INSIDE OF CUFF USING VIBRATING STYLUS.
- 7) WEIGHT: 21.9 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT EDGE LONGITUDINALLY,
TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE
TO BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2892-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER
QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-22 CLAMPS WITH D3595-063-450 RUBBER CUSHIONS TO SECURE THE
D2892-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMP MECHANISMS ARE
LOCATED ON CROSSTUBE SUPPORTS.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE
OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS
SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT
LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN.-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN
SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

RELEASED
08/11/06

C	REVISE GENERAL NOTES/PART LIST (ZN D7-1); REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS. D3595-063-450 WAS D2856-400-773 (ZN D6-2 & A5-2); REMOVED REF. & ADD TOLERANCES (ZN 4-3, C5-3, D3-3); RELOCATED FLAG #6 (ZN A8-3) PER NCR 210; MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4.	RF	08.11.06
B	ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKUDTUBES	PH	05.07.26
A	NEW ISSUE	CP	00.11.17
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF	DRAWING NO.	REV. C
CHECKED	RF	D206-667-243	SHEET 1 OF 4
MFG. APPR.	RF	TITLE	SCALE
APPROVED	RF	CROSSTUBE ASS'Y (206L HIGH AFT)	NTS
DE APPR.	RF	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	08.11.06		

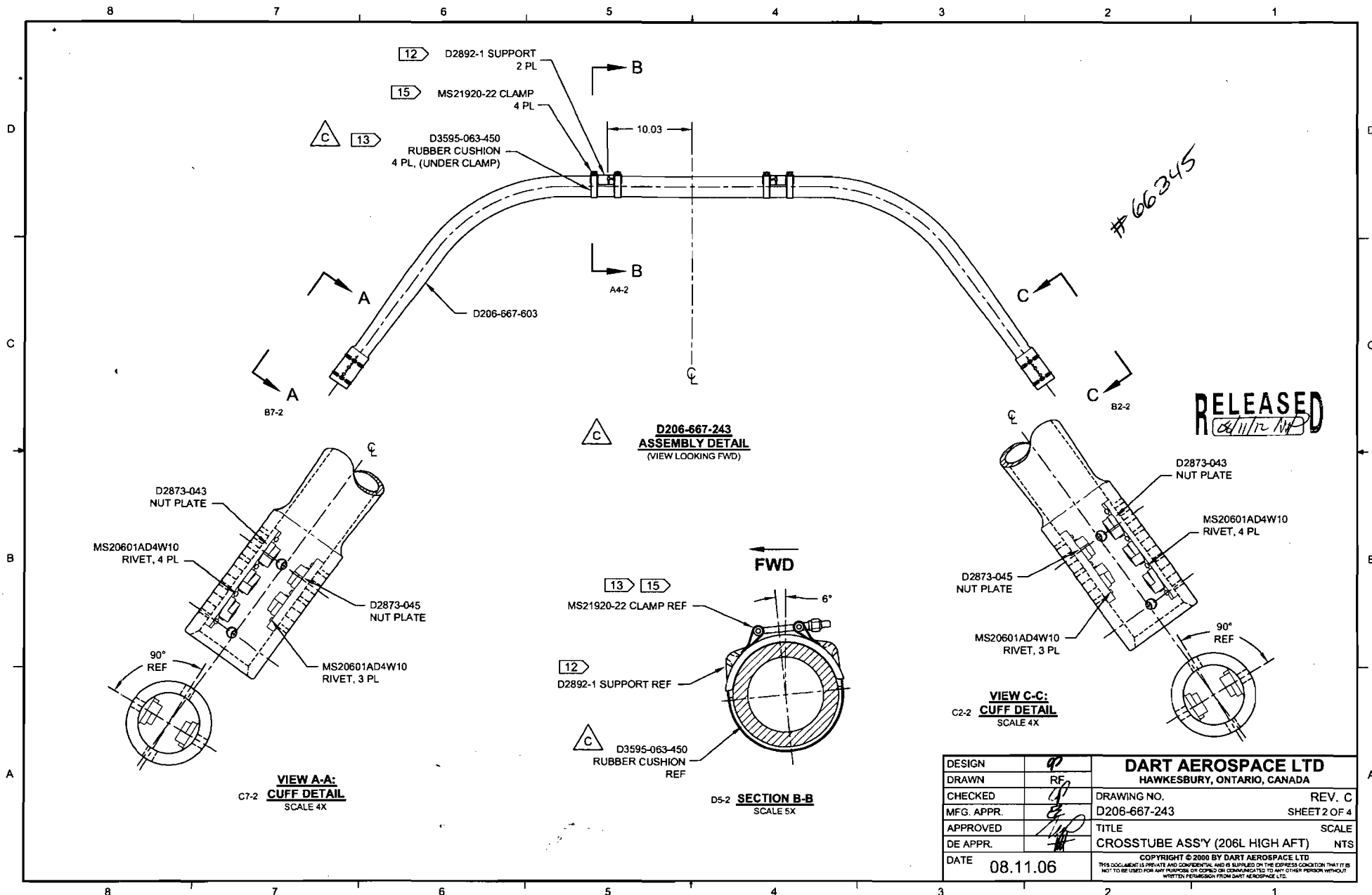
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



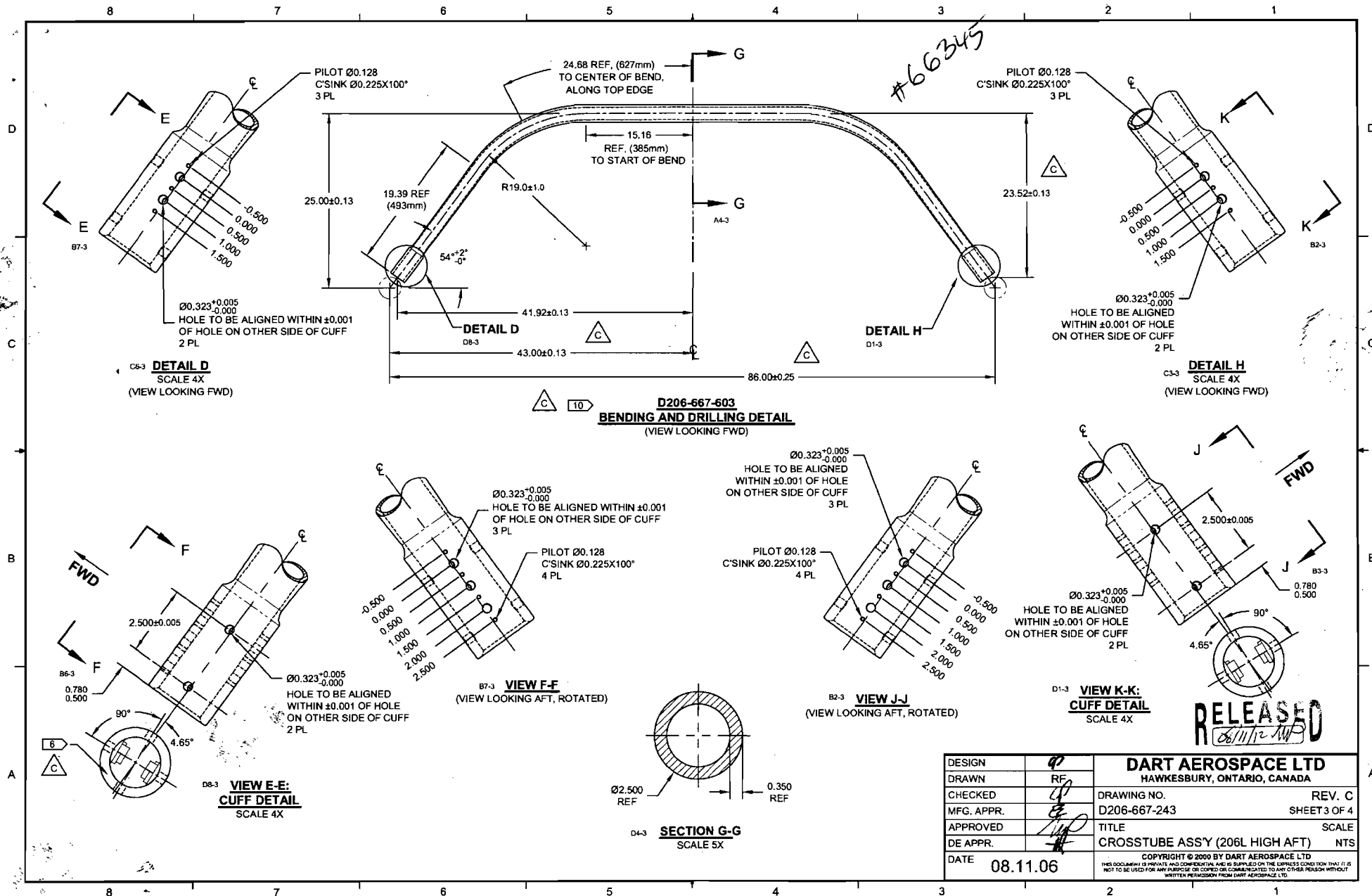
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

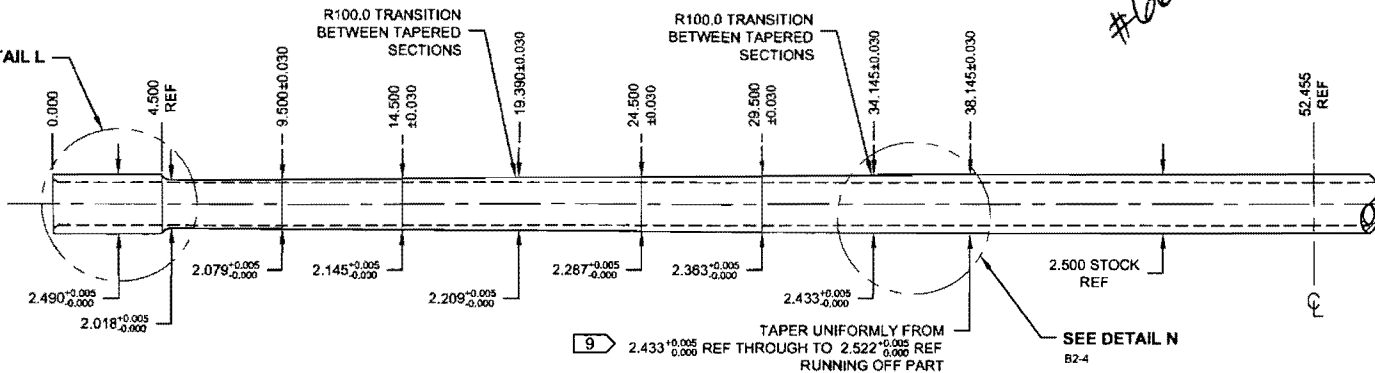
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

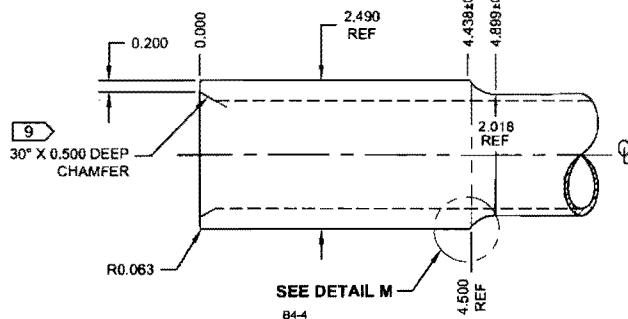
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

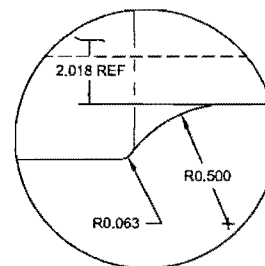
SEE DETAIL L
B7-4



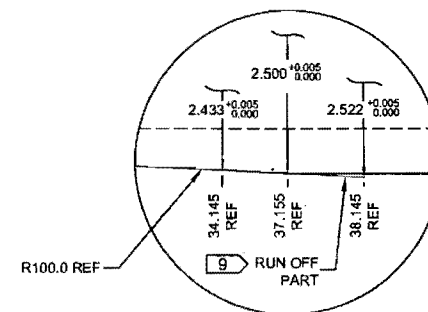
TURNING DETAIL



DETAIL L: CROSSTUBE CUFF
NOT TO SCALE



DETAIL M: CUFF TRANSITION
NOT TO SCALE



DETAIL N: TAPER RUN-OFF
NOT TO SCALE

RELEASED
08/11/12

DESIGN	9	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	RF	D206-667-243	SHEET 4 OF 4
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	CROSSTUBE ASSY (206L HIGH AFT)	NTS
DATE	08.11.06	COPYRIGHT © 2000 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



ACUREN

RAPPORT D'INSPECTION PAR RESSUAGE

P- 12618

PAGE 1 DE 1

CLIENT: DART AEROSPACE
 ATTENTION: LINDA CHANTE
 ADRESSE: 1270 ABERDEEN ST
 HAWKESBURY, ONTARIO
 PROJET: FPI ON 10 CROSSTUBE
 ITEM(S) EXAMINÉ:
 DATE: 2011-04-05 HEURE: 7:30 AM ☐ PM
 N° TRAVAIL: 188-11-02070
 ACUREN
 N° CLIENT PO/WO: 13801
 SITE DE TRAVAIL: HAWKESBURY
 ACCEPTATION STD.: ASTM E1417 / QSL-038 DATE/REV.: 2005

DESCRIPTION DES TRAVAUX: N° PROCÉDURE: LT-002 DATE/REV.: 2008 N° TECHNIQUE: LT-002-1011 DATE/REV.:
 N° ITEMS: MATÉRIEL: ALUM. 2024 ÉPAISSEUR: VARIÉS
 DESCRIPTION: wet Fluorescent Liquid Penetrant Inspection
 CARRIED OUT ON 100% EXTERNAL SURFACE

DÉTAILS DES INSPECTIONS

MÉTHODE: ☒ FLUORESCENT ☐ VISIBLE ☒ LAVABLE À L'EAU ☐ MÉTHODE DISSOLVANT ☐ PRÉ-ÉMULSIONNANT
 MARQUE: MAGNAFLUX LUM. NOIRE S/N 6404273 PUISS. > 1 000 µ W/cm² ☐ AMBIANT < 2 fc
 PÉNÉTRANT: 2LG7 TEMPS PÉNÉTRATION MIN. 45 MIN. ÉQUIP. LUMIÈRE: ☒ LAMP. POCHÉ ☐ LAMP. CULASSE ☐ PUISS. > 100 fc @ SURFACE
 DISSOLVANT PÉNÉTRANT: H2O TEMPS SÉCHAGE MIN. > 10 MIN. AUTRES:
 RÉVÉLATEUR: SPS2 TEMPS RÉVÉLATION MIN. 10 MIN. MÈTRE LUM. N/S DATE CAL DUE: 07/19/2011
 TYPE RÉVÉLATEUR: ☒ NON AQUEUX ☐ AQUEUX ☐ SEC 189886

SURFACE INSPECTÉE

CONDITION SURFACE: ☐ MEULÉE ☐ SOUDÉE ☐ MACHINÉE ☐ MRENAILLÉE ☒ MÉTAL PROPRE
 TEMPÉRATURE SURFACE: ☐ < - 4°C/20°F ☐ - 4°C/20°F à 10°C/50°F ☒ 10°C/50°F à 52°C/125°F ☐ > 52°C/125°F

RÉSULTATS (☐ MÉTRIQUE ☐ IMPÉRIALE)

ITEM	COMMENTAIRES	ACCEPTÉ	REJETÉ
1	CROSSTUBE WO 66346	✓	
1	CROSSTUBE WO 67211	✓	
1	CROSSTUBE WO 67210	✓	
1	CROSSTUBE WO 65700	✓	
1	CROSSTUBE WO 65699	✓	
1	CROSSTUBE WO 67868	✓	
1	CROSSTUBE WO 67869	✓	
1	CROSSTUBE WO 67439	✓	
1	CROSSTUBE WO 67440	✓	
1	CROSSTUBE WO 66345	✓	

Étendue des Services

L'entente selon laquelle le Groupe Acuren Inc. Exécute les services ne concerne que les énoncés par écrit. En aucune circonstance ces services ne s'étendent au-delà de l'exécution des services demandés. Il est entendu que toutes les descriptions, les observations et les expressions d'opinions faites par Acuren reflètent les opinions ou les observations de l'entreprise fondées sur l'information et les hypothèses fournies par le propriétaire/opérateur, et elles ne constituent pas des déclarations ou des garanties ou ne peuvent être interprétées comme constituant. Le Groupe Acuren Inc. N'assume aucune des responsabilités du propriétaire/opérateur, et le propriétaire/opérateur conserve la responsabilité entière des décisions prises en matière d'ingénierie, de fabrication, de réparation et d'usage à partir de l'information ou des données fournies par Acuren en rapport avec les services décrits dans les présentes ne peuvent excéder le coût des services rendus.

Norme de Diligence

Dans l'exécution des services, le Groupe Acuren Inc. Applique le degré de diligence, le soin et la compétence normalement exercés dans des circonstances semblables par d'autres fournisseurs de ce type de services opérant dans la même localité ou dans une localité similaire. Aucune autre garantie, implicite ou explicite, n'est faite ou voulue par le Groupe Acuren Inc.

SIGNATURES

REPRÉSENTANT: Matthew Murdoch MOULÉ: Matthew Murdoch
 TECHNICIEN (SIGNATURE): [Signature] SIGNATURE:
 NOM (MOULÉ): David Rechin 1^{er} TECHNICIEN
 ONGC NIVEAU: 2 SNT NIVEAU: ONGC N° REGISTRATION: 2nd TECHNICIEN
 FTJ#: RAPPORT RÉVISÉ PAR: NOM: INITIALES:

